



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-041

Job Sheet 176961



Part No: D4681-041

Job Qty: 4 ea

Part Name: Web Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: AOG

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/30/18

Created By: Michelle Gagnon-Donovan

Type: AOG

Description:

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/30/18	5/30/18	0.00	0.00	Start Up Skid tubes-2		1.4
110	Skid tubes	4 pcs	5/30/18	5/30/18	0.00	3.45	Skid tubes-2		DD 1.4
120	QC	4 pcs	5/30/18	5/30/18	0.00	0.00	QC6		BE
121	CNC Vertical Machining	4 pcs	5/30/18	5/30/18	0.18	2.63	HAAS1-5		HAAS 1.8/05/14
122	QC	4 pcs	5/30/18	5/30/18	0.00	0.00	QC2 Machining-3		2mm 1.8/05/15
123	QC	4 pcs	5/30/18	5/30/18	0.00	0.00	QC8 Machining-3		SA 1.8-05-15
130	HandFinish	4 pcs	5/30/18	5/30/18	0.00	1.12	HandFinish1		1.4
140	QC	4 pcs	5/30/18	5/30/18	0.00	0.00	QC7-4		1.4
150	Skid tubes	4 pcs	5/30/18	5/30/18	0.00	3.45	Skid tubes-3		1.4
160	QC	4 pcs	5/30/18	5/30/18	0.00	0.00	QC5		1.4
170	Packaging	4 pcs	5/30/18	5/30/18	0.00	0.00	Packaging3-2		1.4
180	QC21-SA	4 Ea	5/30/18	5/30/18	0.00	0.00	QC21		1.4

Part Op 110 - 1- CUT TO LENGHT AS PER DWG

Descriptions: 121 - MILL AS PER DWG AND FOLIO FB186 DWG REV: _____ FOLIO REV: _____
150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R
PROSEAL: 1138784 exp: 9/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	4 Ea (1 ea)	90-Start up Operation	B156872
D4681-3	Doubler	8 Ea (2 ea)	150-Skid tubes	5041165
MS20470AD4-6	Rivet, Universal Head	356 Ea (89 ea)	150-Skid tubes	128552

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2963-125	4	134	0
150-Skid tubes	D4681-3	8	8	0
	MS20470AD4-6	356	4,218	0



Container No: S070345



Part: D4681 - 041

Job No: 176961

Serial No/Batch: S070345

Revision: b

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/10/18

5/3/2018

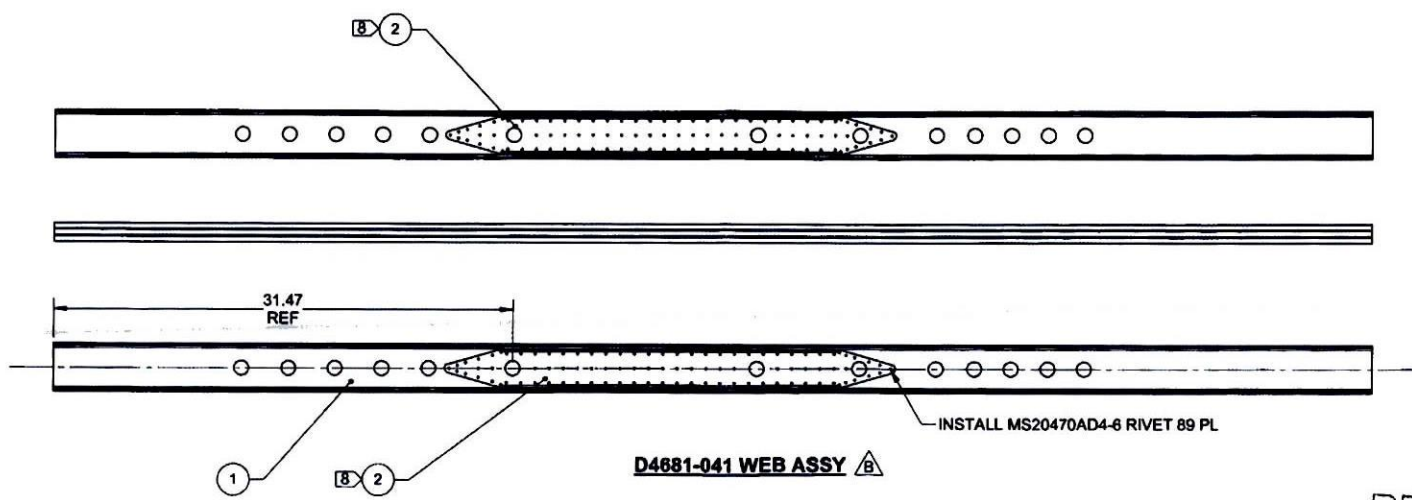
[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

Part Specifications
Specifications could not be found.

Plex 5/3/18 1:29 PM Dart.Gagnon.Michelle

SHOP COPY
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 176961
 MAY 03 2018

ITEM	QTY	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 5.94 lbs
 - 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

B	MS20470AD4-6 WAS MS20470AD4-7, ADDED DETAIL A ON SHEET 2. VARIOUS DIMENSIONAL CHANGES.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	AS		
MFG. APPR.	9/		
APPROVED	3/		
DE APPR.			
DATE	13.08.08		

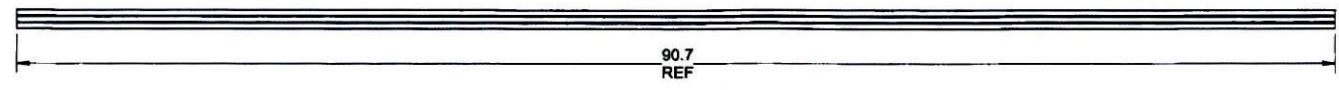
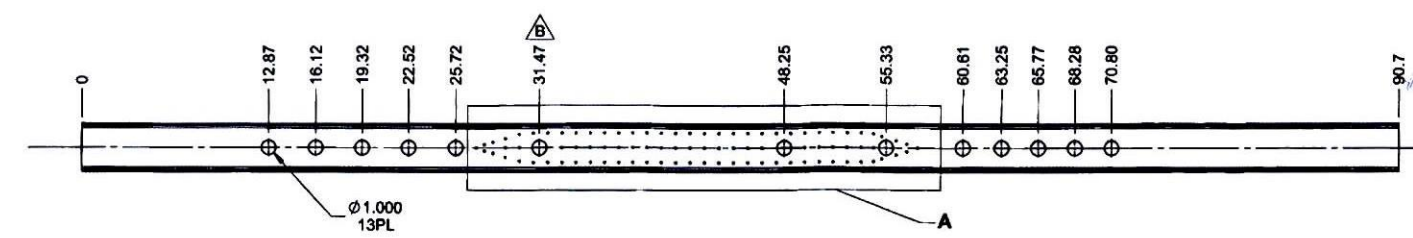
DART AEROSPACE USA, INC.
 KENT, WA

DRAWING NO. **D4681**
 TITLE **WEB ASSY**

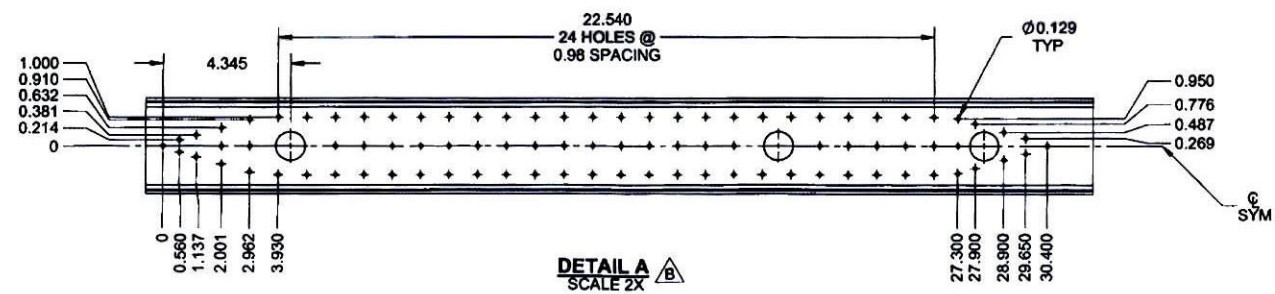
REV. B
 SHEET 1 OF 4
 SCALE
 NTS

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8 7 6 5 4 3 2 1



D4681-1 WEB



DETAIL A
SCALE 2X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	AP	D4681	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
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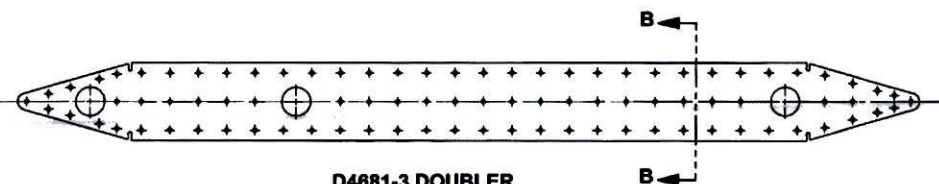
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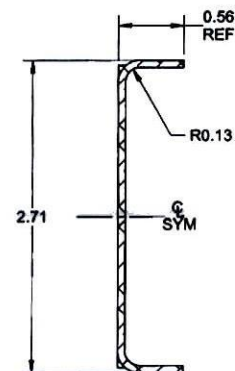
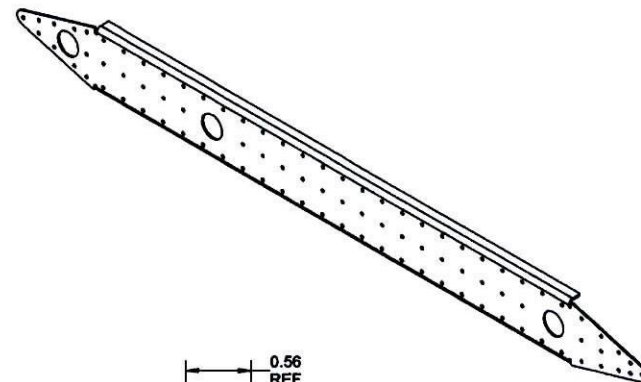
C

B

A



D4681-3 DOUBLER



SECTION B-B
SCALE 4X

RELEASED
2013-11-13
JMP

NOTES:

- 1) MATERIAL: MAKE FROM D4681-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: .56 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	<i>ALS</i>	DRAWING NO. D4681	REV. B
MFG. APPR.	<i>MS</i>	SHEET 3 OF 4	
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	WEB ASSY	NTS
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8 7 6 5 4 3 2 1

